

Split

Work Order ID 66891 -1

Wednesday, March 02, 2011 10:11:29 AM



Item ID: D3243-041
Revision ID:
Item Name: Bracket Assembly
Start Date: 3/2/2011 Start Qty: ⁶5.00
Required Date: 3/23/2011 Req'd Qty: 5.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:
Customer:



Approvals: Process Plan: WME
QC:

Date: 11-03-02 Tooling:
Date: SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3243	Rev A								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
Waterjet		0.00							
FLOW CNC Waterjet	Memo								
6061 - 003	1-Cut as per Dwg								
	Dwg Rev: <u>1</u>								
	Prog Rev: <u>1</u>								
	2-Deburr if necessary								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								

FB11-3-3

FB11-3-3

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Reference:

Approvals: Process Plan:

Date:

QC:

Date:

Sequence ID/
Work Center ID

Operation
Description

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11 03 03 10

150

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Bwg D3243

SB 11/03/04

10

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/03/04

4/0

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Accept



Setup Start



Revision ID:

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Stop



Start Date: 3/2/2011 Start Qty: 5.00



Required Date: 3/23/2011 Req'd Qty: 5.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 BR 11-3-7.

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D3343

EP 11/03/08

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/03/08

(x6)

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

200



Powdercoat

Powder Coating

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M 112588

Memo

*****Mask Holes*****

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*11:45
320°
12:15*

Set Up/
Run Hours

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			<i>6</i>		<i>BR 11-3-9.</i>	

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

G b JD 11/03/09

220



Packaging

Packaging

Identify as per dwg & Stock Location: *227*

0.00

Memo

0.00

4/3/9 (6)

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Page 5

Item ID: D3243-041

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Start Date: 3/2/2011 Start Qty: 5.00

Required Date: 3/23/2011 Req'd Qty: 5.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

230

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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QC

Memo

0.00

Quality Control



Accept



Setup Start



Stop



Cust Item ID:

Customer:



11/3/10 *[Signature]*

CL11/03110

Checklist Print

Wednesday, March 02, 2011 10:11:26 AM

Page 1

Work Order ID: 66891

Parent Item: D3243-041

Parent Item Name: Bracket Assembly



Start Date: 3/2/2011

Required Date: 3/23/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

FE-032-EF Purchased No



Inserts

f

Location

Loc Qty

Loc Code

ST285

26

110836

26

M6061T6S.063 Purchased No



6061-T6 .063 Sheet

110 sf

145.5000

0.5499

2.894211



21

6,
RB11-3-3

Location

Loc Qty

Loc Code

MAT

111.6

116308

28.6

116623

83

MAT21

33.9

113608

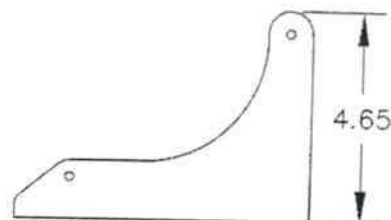
33.9

116623

(10)

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A
DATE 04.01.09		TITLE BRACKET	SHEET 1 OF 1
A	04.01.09	NEW ISSUE	SCALE 1:2



R0.188 (TYP)



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

RELEASED
04 02 03

66891
INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75^{+0.030}_{0.000}

8.581

8.206

7.706

GRAIN
DIRECTION

11.920

11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

1.375

5.273

3.714

4.214

R0.25 (TYP)

3.339

R0.38
(TYP)

5.494

R2.75
(TYP)

0.500

0.000

D3243-1
FLAT PATTERN

R0.50
(TYP)

6.560

5.810

5.360

0.750

0.500

0.000

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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